

## CLAIMS

What is claimed is:

- 5 1. A threading control method for performing a threading operation by moving, in synchronization with rotation of a main spindle, either a cutter or a workpiece in a feeding spindle direction, characterized in that threading start timing is altered based on at least a servo-spindle acceleration time-constant for the feeding  
10 spindle.
2. A threading control method for performing a threading operation by moving, in synchronization with rotation of a main spindle, either a cutter or a workpiece in a feeding spindle direction,  
15 characterized in that threading start timing is altered based on at least a servo-spindle acceleration time-constant for, and mechanical error of, the feeding spindle.
3. A threading control system for performing a threading operation  
20 by moving, in synchronization with the rotation of a main spindle, either a cutter or a workpiece in a feeding spindle direction, the system comprising a means for altering threading start timing based on a servo-spindle acceleration time-constant for the feeding spindle.

4. A threading control system for performing a threading operation by moving, in synchronization with the rotation of a main spindle, either a cutter or a workpiece in a feeding spindle direction, the system comprising a means for altering threading start timing
- 5 based on a servo-spindle acceleration time-constant for, and mechanical error of, the feeding spindle.